100159

April-18-13 1:20:06 PM

Item ID: D4030-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Assembly (350) **Start Date:** 4/18/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 5/02/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13-04-18 Approvals: Tooling: Date: _____ Date: **SPC** (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description Run Hours Qty Qty Code Number Stamp **Draw Nbr Revision Nbr** D4030 C 100 Pick Kit 0.00 *100* Packaging 0.00 Memo Packaging 110 Assemble as per dwg 0.00^{1} 1 \$ Bl 13-5-7 *110* HandFinish 0.00^{1} Memo Hand Finishing ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label **** 120 QC5- Inspect part completeness to step on W/O 0.00 *120* 0.00 Memo Quality Control

| NCR: Y | es / No | | | | WORK ORDER NO | ON-CO | NFORM | MANCE / UP | DATE | DQA: QA Closed: | | |
|---|--|------|-----|-----|--|-------|---|--|-----------------|--|---|--|
| Work Orde | r: | | · | | DISPOSITION | _ | | Skid-tube | AGAINST DE | PARTMENT, | /PROCESS Water Jet | Engineering |
| Part N NCR N | | | | | Use-as-is Thermo | | | ~ | | | d. Eng. Coor. re/Packaging Supplier | Quality Other |
| Root Cause | Date | Step | Qty | • | otion of work order upd or Non-conformance | | Initial hief Eng | | tion ription | Sign & Date | Verification | QC Inspector |
| Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | |
| | | | | | | FAL | ILT CATE | GORY | | | | |
| Landin | Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence | | | O/S | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish | | Instruct Mainte Mislabe Misreae Offset Out of | ion Incomplete ions Incomplete/ enance eled | Unclear | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/ | ct sissing | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| } | Wave/Tw | | | | Folio | - | ⊣ | e Dimensions | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

Packaging

Item ID: D4030-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Assembly (350) **Start Date:** 4/18/13 Start Qty: 1.00 Cust Item ID: Required Date: 5/02/13 Req'd Qty: 1.00 *1* **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: QC: _____ Date: **SPC** (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject **Work Center ID** Description Qty **Run Hours** Code Qty 130 Identify as per dwg & Stock Location: 0.001 8 13-5-8 *120*

0.00

100159

140 QC21- Final Inspection - Work Order Release 0.00 *140* OC 0.00Memo Quality Control

Memo

Reject

MCJ 1305-09

Insp.

Number Stamp

| | | | | | | 1 | | | | | | | DQA: | Date | e: | |
|---------------|-------------------|-----------|----------|-------------|--------|---------------------------|--------------|------------|---------------------|------------------------|----------|------------------|----------------------|--------------|-------------------|---------------------------------------|
| NCR: | Yes / | No | | | | WORK O | RDER NON- | CON | NFORN | /IANCE / UP | DATE | | | Data | | |
| | | | | | | | | | | | | | QA Closed: | Date | | ersten in the teachers and the second |
| Work Orde | ٥. | | | | | DIS | POSITION | | | | AGAINS | T DE | PARTMENT/ | PROCESS | | |
| Work Orde | er | | | | | ; | Rework | 1 l | Skid-tube Crosstube | | | , |] | Water Jet | 7 , | Engineering |
| Part N | No | | | | | : | Scrap | | Machining Small Fab | | | Prod. Eng. Coor. | | | Quality | |
| NCR No. | | | | | Work C | Use-as-is Order Update | | | Large Fab | Finishing Composite | | Rec/Stor | e/Packaging Supplier | | Other | |
| Root | | | | | Descri | ption of work | order update | | nitial | Ac | ction | | Sign & | | | |
| Cause | D | ate | Step | Qty | C | or Non-confo | rmance | Ch | ief Eng | Desc | cription | | Date | Verification | | QC Inspector |
| Doc/Data | | | | | | ; | | | | | | | | | | |
| Equip/Tooling | | | | | |) | | | | | | | | | | |
| Operator | | 1 | | | | i | | | | | | | | | | |
| Material | | | | | | i | | | i | | | | | | | |
| Setup | | | | | | 1 | | | | | | | | | | |
| Other | | | | | | İ | | | | | | | | | | |
| Process | | 1 | | | | F | | 1 | | | | | | | | |
| Supplier | | | | | | Į. | | | | | | | | | | |
| Training | П | | | | | 1 | | | | | | | | | | |
| Unapproved | $\prod_{i=1}^{n}$ | | | | | | | | | | | | | | | |
| | | | | | | | F | AUL | T CATE | GORY | | | | | | |
| Landi | ng Gear | | | | | Gei | nera! | | _ | | | | _ | , | | |
| | Ber | iding | | | | Bend; | | | Grain | | | | Ovalized | L | Pr | ressure/Forced |
| | Cer | itre No | t Concer | ntric to | o/s | BOM/Route | ! | | Hardwa | re | | | Over/Under | tolerance | Te | emperature/Cure |
| | Cra | cks | | | | Broken/Dan | naged | | Inspecti | on incomplete | | L | Part Incorred | ct _ | \w | /eld |
| | Crushed/Crimped | | | | Burrs | | | Instruct | ions Incomplete, | /Unclear | | Part Lost/Mi | issing | \w | rong Stock Pulled | |
| | Cuf | fs | | | | Contamination | on | | Mainte | nance | | | Part Moved | | | |
| | Hea | at Treat | | | | Countersink | | | Mislabeled | | | | Positioned V | Vrong _ | | |
| | Ins | ection | Strip in | Tube | | Cut Too Shor | t | | Misread | l | | | Power Loss/ | Surge | 0 | ther |
| | Rin | nles in l | Bend | | | Drill Holes | | Offset | | | | _ | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Picklist Print

April-18-13 1:20:10 PM

Work Order ID: 100159

100159

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as IPP Rev: as per dwg

revC DD 10.08.18 verified by:EC

IPP Rev D 12.03.27 per NCR12-

1239 EC verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D4086-200 | | Manufactured | No | | | | Each | 19.0000 | | 1 | ··· | | + |
| *D4086-20 | ገበ* | | | | | | | | ** | | - |) | |
| | | | | Location | | Loc | <u>Oty</u> | Loc Code | | | 01 | | |
| | | | | ST093 | | | 19 | | _ | | <u></u> | | |
| | | | | | 88611 | | 5 | | _ | LX. | _ | | |
| | | | | | 96251 98519 | | 4 | | _ | | _ | | |
| D2530 | | Manufactured | No | | 96319 | 100 | 10 Each | 15.0000 | 1 - | 1 | _ | | |
| *D2530* Handle Weldment | | Manufactured | ,,, | | | 100 | Eden | 13.0000 | ** | 1 | 80 | • | |
| | | | | Location | <u> </u> | <u>Loc</u> | <u>Oty</u> | Loc Code | | | • | | |
| | | | | ST205 | | | 10 | | | | | | |
| | | | | | 87086 | | 10 | | | /X | _ | | |
| | | | | ST255 | - | | 5 | | _ | | | | |
| 20505 | | | | | 86369 | | 5 | | _ | | _ | | |
| D2535 | | Manufactured | No | | Ì | 100 | Each | 50.0000 | 2 | 2 | | | |
| *D2535* | | | | | | | | | ** | | -86 | 13-5- | -7 |
| | | | | Location | | Loc | Qty | Loc Code | | | | | |
| | | | | ST011 | | | 50 | | | | - | | |
| | | | | | 96248 | | 50 | | _ | 2 | λ | | |
| | | | | | | · · | | | | Ū | | | |

| | | | | | | | | DQA: | Date: | |
|---------------|----------|------|-------------|----------------------------------|-------------------------|------------|------------|------------------|---------------------------------------|--|
| NCR: Y | Yes / No | | | WORK ORDER NON- | CONFOR | MANCE / UF | PDATE | | · · · · · · · · · · · · · · · · · · · | |
| | | | | t. | | o om | | QA Closed: | Date: | the state of the s |
| Work Orde | ar· | | | DISPOSITION | | | AGAINST DE | PARTMENT | /PROCESS | |
| VVOIR OTGE | | | | Rework | 7 | Skid-tube | Crosstube |] | Water Jet | Engineering |
| Part N | No. | | | Scrap | Machining Small | | Small Fab | Prod. Eng. Coor. | | Quality |
| | | | | Use-as-is | Thermoforming Finishing | | Rec/Sto | re/Packaging | Other | |
| NCR N | No | | | Work Order Update | | Large Fab | Composite |] | Supplier | |
| Root | <u></u> | Т | | Description of work order update | Initial | Δ | ction | Sign & | | |
| Cause | Date | Step | Qty | or Non-conformance | Chief Eng | I | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | f 1 | | | | | | |
| Setup | | | | ! | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | ļ | | | | | |
| Supplier | | | | | | | | | | |
| Training | Щ | | | j | | | | | | |
| Unapproved | | | | i | | <u> </u> | | | <u> </u> | |
| | | · | | | FAULT CATE | GORY | | | | |
| Landi | ng Gear | | | ' General | _ | | _ | 7 | | 1 |
| Bending | | | | Bend' | Grain | | } | Ovalized | | Pressure/Forced |

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

Work Order ID: 100159

100159

No

No

No

Manufactured

Manufactured

Manufactured

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

2

Start Qty: 1.00 2

Required Qty: 1.00

D2537

Bushing

Manufactured No 100 Each 96.0000

**

Location Loc Qty Loc Code ST008 24 99011 24 ST011 72 92711 8 94713 40 98426 24 100 0.0000 Each ** 100167. 100 Each 0.0000 ** 100175 100 90.0000 Each **

Long Basket Base Assemby, 350

D3914-041

D3913-041

D3914-041

1. 52.5

Long Basket Lid Assembly (350) D3917-3

D3917-3

Washer

Location Loc Qty Loc Code ST072 92514 94136 5 94643 24

60

97710

| | | | | | 1 | | | | | DQA: | Date: | | |
|---------------|--------------------------|------------|----------------|--------------|---|--------------------|--|----------------|----------|--------------|---|---------------------------|--|
| NCR: Ye | es / No | | | | WORK ORDER NON-O | CON | IFORM <i>i</i> | ANCE / UP | DATE | QA Closed: | Date | | |
| Work Order | | <u></u> | st <u>1</u> /2 | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Part No | | | | | Rework Scrap Use-as-is Work Order Update | | Skid-tube Crosstube Machining Small Fak Thermoforming Finishing Large Fab Composite | | | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other | |
| Root | | | | | ption of work order update | 1 | nitial | | tion | Sign & | | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chi | ief Eng | Desc | cription | Date | Verification | QC Inspector | |
| Doc/Data | | | | | (| | | | | | | | |
| Equip/Tooling | | | | | 1 1 | | | | | | | | |
| Operator | | | | | ! | | | | | | | | |
| Material | | | | | , 1 | | • | | | | | | |
| etup | | | | | i | | | | | | | | |
| Other | _ | Ì | | | | | | | | | | | |
| rocess | _ | | i i | | 1 | Ì | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | ! | | | | | | | | |
| Unapproved | _1 | <u> </u> | 11 | | | A 1 11 7 | T CATEGO | | | .1 | L | | |
| Landin | - Con- | | | " | , General | AUL | CATEGO | <u> </u> | | | | | |
| Lanun | Bending | | | | Bend | | Grain | | F | Ovalized | | Pressure/Forced | |
| - | Centre No | nt Conce | ntric to C |)/5 | BOM/Route | \vdash | Hardware | | - | Over/Under | tolerance | Temperature/Cure | |
| H | Cracks | or contect | | " | Broken/Damaged | \vdash | | n Incomplete | <u> </u> | Part Incorre | <u> </u> | Weld | |
| F | Crushed/ | Crimped | | | Burrs | | • | ns Incomplete/ | /Unclear | Part Lost/M | ├ | Wrong Stock Pulled | |
| - | Cuffs | | | F | Contamination | \vdash | Maintena | | | Part Moved | | - | |
| <u> </u> | Heat Trea | ıt | | | Countersink | H | Mislabele | d | - | Positioned \ | | | |
| t | Inspection Strip in Tube | | | | Cut Too Short | \vdash | Misread | | · | Power Loss, | | Other | |
| <u> </u> | Ripples in | | | - | Drill Holes | | Offset | | _ | | | | |
| | Torque W | | Extrusion | | Drawing | \vdash | Out of Cal | libration | | | | | |
| T T | Turning Sequence Finish | | | | | | Out of Sequence | | | | | | |
| <u> </u> | ─ Wave/Tw | • | | | Folio | Outside Dimensions | | | | | | | |

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Work Order ID: 100159

100159

Parent Item:

D3953-3

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Manufactured

Manufactured

Manufactured

No

No

Start Date: 4/18/13 Start Qty: 1.00

2

Required Date: 5/02/13

Required Qty: 1.00

**

34.0000

Gas Spring Stud, Lid

| Location | <u>n</u> | Loc Qty | Loc Code |
|----------|----------|---------|----------|
| GA | | 1 | |
| | 87592 | 1 | |
| ST076 | Ì | 21 | |
| | 88494 | 14 | |
| | 94744 | 7 | |
| CT17/ | | 10 | |

100

Each

1 4 5

ST176

12 12 100 Each

58.0000

**

**

Spring Spacer

D3953-7

D3953-9

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST076 | 58 | |
| 94669 | 34 | |
| 99148 | 24 | |

100

Each

65

20

45

99148

65.0000

2

Gas Spring Washer

Location ST076

94719

95127

Loc Qty

Loc Code

| | | | | | | ı | | | | | | DQA: | Da | te: | |
|---------------|--|------------------------|------|-----|-------|-----------------------------|---------------------------------|----------------------------|------------|-------------------|----------------------|-----------------|--------------------|------------------|--------------|
| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORM | MANCE / UP | DATE | | • | | | |
| | | | | | | | | | | | | QA Closed: | Da | te: | |
| Monte Ond | ~ " . | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| Work Orde | er: | | | | | Rework | 7 | | Skid-tube | Crosstube | \neg | | Water Jet | | Engineering |
| Part N | No. | | | | | Scrap | - 1 | Machining Small Fab | | | Prod. Eng. Coor. | | | Quality | |
| raiti | VO. | | | | | Use-as-is | 1 | | noforming | Finishing | - | | e/Packaging | \Box | Other |
| NCR No. | | | | | | Work Order Update | 1 | | Large Fab | Composite | 7 | , | Supplier | _ | |
| | | | | | | | | | | | | | | | |
| Root | | · | | | Descr | iption of work order update | | nitial | Ac | tion | | Sign & | | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Ch | ief Eng | Desc | ription | | Date | Verificatio | n | QC Inspector |
| Doc/Data | | | | | | į. | | | | | | | | | |
| Equip/Tooling | | | | | | l · | | | | | | | | | |
| Operator | | | | | | | | | | | | | | ļ | |
| Material | | | | | | i i | | | | | | | | | ! |
| Setup | | | | • | | Ī | | | | | | | | | |
| Other | | | | | | 1 | | | | | | | | ļ | |
| Process | | | | | ŀ | ' | | | | | | | | | |
| Supplier | | | 1 | | | • | | | | | | | | | |
| Training | | | ļ | | | | | | | | | | 8 1 | | |
| Unapproved | | | | | | · | | | | | | | | | |
| | | | | | | ; | FAUL | T CATE | GORY | | | | | | |
| Landi | ng (| Gear | | | | General | | _ | | - | | • | | _ | 1 |
| Bending Bend | | | | | Grain | | | | Ovalized | | | Pressure/Forced | | | |
| | Centre Not Concentric to O/S BOM/Route | | | | | | Hardwa | re | Ĺ | | Over/Under tolerance | | | Temperature/Cure | |
| | | Cracks Broken/Damaged | | | | L | Inspect | ion Incomplete | | | ` | | Weld | | |
| | | Crushed/Crimped. Burrs | | | | | Instructions Incomplete/Unclear | | | Part Lost/Missing | | | Wrong Stock Pulled | | |

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID: 100159

100159

Parent Item:

D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

**

Required Qty: 1.00

D3953-17

Manufactured No 100

Each

44.0000

Gas Spring Spacer

| <u>Location</u> | Loc Qty | Loc Code |
|-----------------|---------|----------|
| ST076 | 44 | |
| 94578 | 12 | |
| 27100 | 12 | |
| 97696 | 20 | |

D3953-19

Manufactured

100

Each 16.0000

**

D3953-19

Gas Spring Bracket

| Location | Lo | c Oty | Loc Code |
|----------|-----|-------|----------|
| ST077 | | 16 | |
| 92819 | | 4 | |
| 97691 | | 12 | |
| | 100 | Each | 18.0000 |

D3953-21

Manufactured

Manufactured

No

**

Gas Spring Bracket

| Locatio | <u>n</u> | | | Loc Qty | Loc Code |
|---------|----------|----------------|-----|---------|----------|
| ST075 | 1.1 | n ^e | ٠. | 12 | |
| | 97714 | | | 12 | |
| ST077 | - | | | 6 | |
| | 94146 | | | 6 | |
| | 1 | | 100 | Each | 16.0000 |

D3969-3

Spring (Basket Lid)

**

Location Loc Oty Loc Code ST262 10 91844 10

6

ST272 97050

April-18-13 1:20:10 PM

Shop Packet Print

Page 4

| | | | | | 1 | | | DQA: | Date: | |
|---|---|--|------|---|---|---|---|--|---|--|
| NCR: Y | es / No | | | | WORK ORDER NON-C | CONFORM | MANCE / UPDATE | QA Closed: | Date: | |
| Work Orde | | | | | DISPOSITION | | AGAIN | IST DEPARTMENT, | PROCESS | |
| Part No. NCR No. Root Desc | | | | | Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite | | | Fab Pro- ing Rec/Stor | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | | 1 | | Descripti | ion of work order update | Initial | Action | Sign & | | |
| Cause | Date | Step | Qty | or | Non-conformance | Chief Eng | Description | Date | Verification | QC Inspector |
| Coc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | |
| | | | | | | AULT CATE | GORY | | | |
| Landin | Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W | Crimped. at n Strip in a Bend Javes in E | Tube | D/S B B B C C C C C C C C C C C C C C C C | General Gend GOM/Route Groken/Damaged Gurrs Gontamination Countersink Gut Too Short Orill Holes Orawing Ginish | Instruct Mainte Mislabe Misread Offset Out of (| ion Incomplete ions Incomplete/Unclear enance eled | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/ | ct sissing Vrong | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| - | Turning Sequence | | | | colio | Outside | ************************************** | | | |

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Picklist Print

April-18-13 1:20:10 PM

Work Order ID: 100159 *100159* *D4030-041* Parent Item: D4030-041 Parent Item Name: Long Basket Assembly (350) **Start Date: 4/18/13** Required Date: 5/02/13 Start Qty: 1.00 Required Oty: 1.00 AN3-14A Purchased No 100 Each 87.0000 *AN3-14A* ** Bolt Location Loc Qty Loc Code ST512 87 123759 87 AN3-16A Purchased No 100 Each 102.0000 *AN3-16A* ** Bolt Location Loc Qty Loc Code GA 47 117441 47 ST352 55 122407 8 123900 47 AN5-17A Purchased No 100 Each 152.0000 *AN5-17A* ** Location Loc Code Loc Qty GA 36 117872 36 ST337 116 124215 50 124805 66 AN4-12 Purchased No 100 Each 71.0000 ** Location Loc Qty Loc Code ST356 71 122800 21 124805 50 April-18-13 1:20:10 PM Shop Packet Print Page 5

| NCR: Ye | es / No | | | | WORK ORDER NON- | CONFOR | MANCE / UP | DATE | QA Closed: | Date: | | | |
|---|--|------|-----|-------------|--|--|--|-------------------------------------|-----------------|-----------------------------------|--|--|--|
| Work Order: | | | | | DISPOSITION | 1 | AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Engineering | | | | | | |
| Part No | | | | | Scrap Use-as-is Work Order Update | Ther | Machining moforming Large Fab | Small Fab Finishing Composite | Pro Rec/Stoi | Quality Other | | | |
| | | | | | | | | | | - | | | |
| Root Cause | Date | Step | Qty | | ption of work order update or Non-conformance | | Initial Action Chief Eng Description | | Sign & Date | Verification | QC Inspector | | |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | | |
| | | , | | | | AULT CAT | EGORY | | | | | | |
| Landin | Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence | | | | General Bend, BOM/Route Broken/Damaged Burrs' Contamination Countersink Cut Too Short Drill Holes Drawing Finish | Hardv Inspection Instru Main Mislal Misre Offset Out o | Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence | | | tolerance ct issing Wrong /Surge | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other | | |

DQA: Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100159 *100159* Parent Item: D4030-041 *D4030-041* Parent Item Name: Long Basket Assembly (350) **Start Date: 4/18/13** Required Date: 5/02/13 Required Qty: 1.00 Start Qty: 1.00 AN310-4 Purchased No 100 Each 72.0000 3 *AN310-4* ** NUT Location Loc Qty Loc Code ST342 72 2 122800 70 AN310C4 Purchased No 100 Each 86.0000 *AN310C4* ** Location Loc Qty Loc Code ST342 86 123831 2 124221 84 MS21042L3 Purchased No 100 4,739.000 Each *MS21042L3* ** Location Loc Qty Loc Code FP001 3 122141 3 GA 114 122452 114 ST314 268 117885 32 119017 55 119075 138 123265 43 ST506 4354 123900 974 (ox

3380

124291

| NCR: Y | 'es / No | | | | WORK ORDE | R NON-C | ONFOR | MANCE / UP | DATE | QA Closed: | Date: | | | |
|---------------------------|------------------|------------------------------|----------|--|--------------------|---------|--|----------------------------|---|--------------|---------------------------|---|--|--|
| Work Orde | er: | | | | DISPOSI | TION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Part No | | | | Rework Scrap Use-as-is Work Order Update | | | Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite | | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | | Engineering Quality Other | | | |
| Root | | | | | ption of work orde | | Initial | Action | | Sign & | Verification | QC Inspector | | |
| Cause | Date | Step | Qty | | or Non-conforman | ce | Chief Eng | Desc | ription | Date | verification | QC inspector | | |
| Doc/Data Equip/Tooling | | | | | , , , | | | | | | | | | |
| Operator | | | | | i | | | | | | | | | |
| Material | | | | | i I | | | | | Ì | | | | |
| Setup | | ĺ | | | | | | | | | | | | |
| Other | | | | | j | | | | | | | | | |
| Process | | | | | í | | | | | | | | | |
| Supplier | | | | | | | | | | | ļ 1 | | | |
| Training | | | | | <u>(</u> : | ļ | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| | | | | | 1 | F.A | ULT CATE | GORY | | | | | | |
| Landii | ng Gear | | | | General | _ | | | _ | - | | ¬ | | |
| | Bending | | | | Bend | | Grain | | | Ovalized | <u> </u> | Pressure/Forced | | |
| | Centre N | Centre Not Concentric to O/S | | | BOM/Route | | Hardwa | are | | Over/Under | tolerance | Temperature/Cure | | |
| | Cracks | Cracks | | | Broken/Damaged | t | inspect | tion Incomplete | | Part Incorre | ct | Weld | | |
| . [| Crushed/Crimped | | | Burrs' | | Instruc | tions Incomplete/ | Unclear | Part Lost/M | issing | Wrong Stock Pulled | | | |
| | Cuffs | | | | Contamination | | Maint | enance | | Part Moved | | | | |
| | Heat Tre | at | | | Countersink | | Mislab | eled | | Positioned \ | Wrong | 7 | | |
| | Inspection | on Strip in | Tube | | Cut Too Short | | Misrea | d | | Power Loss/ | 'Surge | Other | | |
| | Ripples i | n Bend | | | Drill Holes | | Offset | | | | | *************************************** | | |
| | Torque V | Waves in I | Extrusio | n [_ | Drawing | | Out of | Calibration | | | | | | |
| | Turning Sequence | | | | Finish | | Out of | Out of Sequence | | | | | | |

DQA: Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order 1D: 100159

Parent Item:

MS21042L5

D4030-041

Parent Item Name: Long Basket Assembly (350)

100159

Location

Location

GA

ST506

D4030-041

Start Date: 4/18/13

Required Date: 5/02/13

Required Qty: 1.00

Start Qty: 1.00

MS21042L5

Nut

MS24665-151

Purchased

Purchased

No

No

No

123900

100

100

337 Each

337

Loc Qty

Each

137.0000

Loc Code

Loc Code

337.0000

**

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MS24665-151 Cotter Pin

MS24665-300

Purchased

MS24665-300

28 17566 28 ST323 109 124859 100

59 50 Each

Loc Qty

219.0000

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Location Loc Qty Loc Code GA 37 118234 37 ST299 182 124555 182

| NCR: Y | es / No | | | | WORK ORDER NON-C | CONF | ORN | MANCE / UP | PDATE | QA Closed: | Date: | |
|---------------------|--------------------|------------------------------|-----------|----------|--------------------------------|--|---|-----------------|-------------------------------|------------------------------|---------------------|--|
| DISPOSITION | | | | | DISPOSITION | DISPOSITION AGAINST DEPARTMENT/PROCESS | | | | | | and the second s |
| Work Order:Part No. | | | | | Rework Scrap | | Skid-tube Crosstube Machining Small Fab | | Water Jet Prod. Eng. Coor. | | Engineering Quality | |
| NCR No. | | | | | Use-as-is Work Order Update | _ | Thermoforming Finishing Large Fab Composite | | | Rec/Store/Packaging Supplier | | Other |
| Root | | | | | ption of work order update | | Initial Action | | | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chief | Eng | Des | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | , | | | | | | | |
| Equip/Tooling | | | | | i I | | | | | | | |
| Operator [| | | | | • | | | | | | | |
| Material | | İ | | | f | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | ; • | | | | | | | |
| Process | | | 1 - 1 | | } | | | | | | | |
| Supplier | | | | | F . | Ì | | | | | | |
| Training | | | | | 1 | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| | | | | | . F | AULT (| CATE | GORY | | | | |
| Landir | ng Gear | | | | General | | | | | _ | | _ |
| | Bending | | | | Bend | G | rain | | | Ovalized | | Pressure/Forced |
| | Centre N | Centre Not Concentric to O/S | | | BOM/Route | На | ardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | Broken/Damaged | In | specti | ion Incomplete | | Part Incorre | ct | Weld |
| | Crushed/Crimped. | | | | Burrs | In | struct | ions Incomplete | /Unclear | Part Lost/M | issing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | М | lainte | enance | | Part Moved | | _ |
| | Heat Trea | at | | | Countersink | М | islabe | eled | | Positioned \ | Wrong | |
| Ì | Inspectio | | Tube | | Cut Too Short | М | isread | i | | Power Loss, | /Surge | Other |
| ļ | Ripples in | | | <u> </u> | Drill Holes | По | ffset | | | - | <u></u> | |
| | Torque W | | Extrusion | , | Drawing | По | ut of (| Calibration | | - | | |
| | Turning S | | | | Finish | По | ut of S | Sequence | | | | |
| | Wave/Twist in Tube | | | | Folio | | Outside Dimensions | | | | | · · · · · · · · · · · · · · · · · · · |

DQA: ____Date: ____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 100159

D4030-041

Parent Item Name: Long Basket Assembly (350)

100159 *D4030-041*

Start Date: 4/18/13

Start Qty: 1.00

Required Date: 5/02/13

Required Qty: 1.00

NAS1149F0432P

Parent Item:

Purchased

No

100

Each

1.878.000

**

NAS1149F0432P

Washer

| <u>Location</u> | Loc Oty | Loc Code | | |
|-----------------|---------|--------------|---|------|
| ST295 | 1878 | | | |
| 12215 | 2 | | | |
| 12352 | 2 4 | | | |
| 12390 | 0 172 | | | |
| 1 <u>2458</u> | 400 | | | -(ox |
| 12485 | | | | |
| 12526 | 8 1000 | | | |
| | 100 Ea | ach 728.0000 | 4 | 4 |

NAS1149F0563P

Purchased

Purchased

No

Location

ST295

Loc Oty

**

NAS1149F0563P Washer

No

728 121350 728 100 Each Loc Code

8,690.000

**

NAS1149F0332P

WASHER

NAS1149F0332P

| 1 | | | |
|-----------------|---------|----------|---|
| <u>Location</u> | Loc Oty | Loc Code | |
| GA | 182 | | |
| 122063 | 182 | | |
| ST294 | 158 | | |
| 122063 | 158 | | |
| ST295 | 3 | | |
| 123352 | 3 | | |
| st510 | 8347 | | |
| 123900 | 8347 | | X |
| | | | |

| NCR: Ye | es / No | | | | WORK ORDER NON-O | CONF | ORN | MANCE / UP | | | | |
|---------------|--------------------|------------------------------|-------------------|------------|----------------------------|--|--------------------|-----------------|------------|----------------------|---------------|--------------------|
| | | | المرازات المرازات | · | 1 | | | | 3 32 | QA Closed: | Date | · |
| Work Order: | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | PROCESS | |
| WOIK Oraci | · | | | | Rework | 7 | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | 0. | | | | Scrap | 1 | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | ┤ | | noforming | Finishing | Rec/Stor | e/Packaging | Other |
| NCR N | o | | | | Work Order Update |] [| | Large Fab | Composite |] | Supplier | |
| Root | 1 | T | Г | Descri | ption of work order update | Init | ial | Ac | tion | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chief | | | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | <u> </u> | | | | | | | |
| Equip/Tooling | | | | | ! i | | | | | } | | |
| Operator | | | | | ; i | | | | | } | | |
| Material | | | | |) [| | | | | | | |
| Setup | | | 1 | | 1 | | | | | | | |
| Other | | | | | 1 | | | | | | | |
| Process | | _ | | | 1 | | | | | | | |
| Supplier | | | . | | 1 { | | | | | | | |
| Training | | ļ | | | i ! | | | | | | | |
| Unapproved | | | | | | | | <u> </u> | | <u> </u> | <u></u> | |
| | | | | | | AULT (| CATE | GORY | | | | |
| Landin | g Gear | | | _ | General | | | | | 7 | г | - |
| | Bending | | | | Bend | | rain | | | Ovalized | - | Pressure/Forced |
| <u> </u> | Centre N | Centre Not Concentric to O/S | | | BOM/Route | \vdash | irdwa | | | Over/Under tolerance | | Temperature/Cure |
| _ | Cracks | | | ļ | Broken/Damaged | | | ion Incomplete | <u> </u> | Part Incorre | | Weld |
| 1 | Crushed/Crimped. | | | | Burrs ¹ | | | ions Incomplete | /Unclear | Part Lost/M | issing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | \vdash | | enance | | Part Moved | | |
| 1 | Heat Trea | | | _ | Countersink | | islabe | | | Positioned \ | | |
| | Inspectio | | Tube | | Cut Too Short | \vdash | isread | d | | Power Loss/ | Surge | Other |
| | Ripples ir | | | <u> </u> | Drill Holes | | fset | | | | | |
| | Torque W | | | \ <u> </u> | Drawing | \vdash | | Calibration | | | | |
| - | Turning S | | | <u> </u> _ | Finish | | | Sequence | | · | | |
| | Wave/Twist in Tube | | | | Folio | Ou | Outside Dimensions | | | | | |

DQA: _____Date: _____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-18-13 1:20:10 PM

Work Order ID: 100159

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

100159 *D4030-041*

Start Date: 4/18/13

Start Qty: 1.00

Required Date: 5/02/13

Page 9

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

1,686.000

Loc Code

**

NAS1149C0432R

Washer

Location ST292

119 24 122441 1686 6 1680

Loc Oty

April-18-13 1:20:10 PM

Shop Packet Print

Page 9

| NCR: Ye | es / No | | | | WORK ORDER NON-C | CONFOR | MANCE / UPI | DATE | QA Closed: | Date | : |
|--------------|--------------------|----------|------------|--------|------------------------------|-----------------|-------------------------------|-------------------------------------|--------------|-------------------------------|--------------------|
| Work Order: | | | | | DISPOSITION | 1 | | AGAINST DE | PARTMENT, | /PROCESS Water Jet | Engineering |
| Part No | Part No. | | | | Rework Scrap Use-as-is | Ther | Skid-tube Machining moforming | Crosstube Small Fab Finishing | l | d. Eng. Coor. re/Packaging | Quality Other |
| NCR No | o | | | | Work Order Update | | Large Fab | Composite | | Supplier | |
| Root | | | | Descri | ption of work order update | Initial | Act | tion | Sign & | i | |
| Cause | Date | Step | Qty | (| or Non-conformance | Chief Eng | Descr | ription | Date | Verification | QC Inspector |
| Doc/Data | | | | | 1 | | | | | | |
| quip/Tooling | | | | | į | | | | | · | |
| Operator | | | | | ! | | | | | | |
| Material | | | | | : | | | | | | |
| Setup | | | | | <u> </u> | | | | | | |
| Other | | | | | i | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | : |
| Training | | | 1 | | ! | | | | | | |
| Unapproved | | | | | <i>t</i> | | | | <u></u> | | |
| | | • | | | F | AULT CAT | EGORY | | | | |
| Landin | g Gear | | | | General | | | | _ | _ | _ |
| Γ | Bending | | | | Bend ' | Grain | | | Ovalized | | Pressure/Forced |
| | Centre No | ot Conce | ntric to (| o/s | BOM/Route | Hardw | are | | Over/Under | tolerance | Temperature/Cure |
| Γ | Cracks | | | | Broken/Damaged | Inspec | tion Incomplete | | Part Incorre | ct | Weld |
| <u> </u> | Crushed/Crimped. | | | | Burrs | Instru | ctions Incomplete/l | Unclear | Part Lost/M | issing | Wrong Stock Pulled |
| ļ. | Cuffs | | | | Contamination | Maint | tenance | | Part Moved | | |
| <u> </u> | Heat Trea | it | | | Countersink | Mislab | eled | | Positioned \ | Wrong | |
| | Inspection | | Tube | | Cut Too Short | Misre | ad | | Power Loss, | 'Surge | Other |
| | Ripples in | • | | | Drill Holes | Offset | | | _ | <u>-</u> | |
| - | Torque W | | Extrusio | , | Drawing | Out of | Calibration | | | | |
| | Turning S | | | | Finish | Out of | Sequence | | | | |
| <u> </u> | Wave/Twist in Tube | | | | Folio | | le Dimensions | | | | |

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





